PRODUCT BULLETIN

July 2019

POLYCOR® 968 HG Series

High Gloss Enamel Gel Coats

DESCRIPTION

POLYCOR® 968 HG (high gloss) Series enamels are formulated to be used as topcoats on fiberglass laminates. POLYCOR® 968 HG enamels seal the laminate surface and provide a high gloss, cosmetically appealing finish.

POLYCOR® 968 HG Series enamels were primarily developed for marine applications; however, they can be used in many FRP applications such as marine hatch covers, bilge and storage areas, camper shell interiors and many others.

POLYCOR® 968 HG Series enamels are available in white. Colors are available upon request.

POLYCOR® 968 HG Series enamels meet the EPA National Emission Standards for Hazardous Air Pollutants (NESHAP) for both Marine Manufacturing and Reinforced Composites Production.

BENEFITS & FEATURES

- Reduce laminate maintenance by sealing with a hard, tough durable coating
- Improve laminate appearance with a high gloss and cosmetically appealing finish
- Good water resistance characteristics
- Tack-free cure
- Reduced emissions due to low HAP content and monomer suppression
- Smoother sprayed film; less orange peel

Enamels cannot be used in-mold like gel coats because they contain surfacing agents that may interfere with adhesion.

Standard enamels should not be used for constant water immersion service due to potential water spotting and water blistering.

PROPERTIES – LIQUID

Property[1]	Unit	POLYCOR® 968 HG Series	POLYCOR® 968 HG Series Brushables
Viscosity[2]	cps	12,000 – 17,000	18,000 – 23,000
Thix Index[3]	-	5.0 – 6.0	5.0 – 6.0
Gel Time[4]	minutes	12 – 17	12 – 14
Tack Free/Dull Gloss Time	minutes	45 – 60	45 – 60
Adhesion Time	hours	4	4
Solvent Wipe Time	-	After overnight cure, slight color may be removed but surface will remain tack free	
Sag Resistance	-	Good @ 20 mils	Good @ 20 mils
Hide	-	Typically complete @ 20 mils	Typically complete @ 20 mils
Weight per Gallon	lbs/gal	12.3 – 12.6	12.3 – 12.6

1) All properties at 25°C/77°F unless otherwise noted
2) Brookfield Viscometer RV Spindle #4 at 4 RPM
3) Brookfield Viscometer RV Spindle #2 at 2/20 RPM
4) 1.8% Arkema Luperox® DDM-9

POLYCOR® 968 HG Series enamels are available in various colors and cure rates. Ask a Polynt representative about a specific formulation.

APPLICATION

POLYCOR® 968 HG Series enamels should be applied after the laminate has cured and while it still has a tacky surface. Glossy/resin rich laminates may cause the enamel to separate, sag, and have poor adhesion. Ensure that glossy areas are well sanded, then blow off the area and clean with solvent.

Tack-free laminates or laminates fabricated with resins containing "wax" or "mold release" should be sanded before coating with POLYCOR® 968 HG Series enamel. Sand with rough sandpaper to remove all indications of wax or mold release, and then wash with solvent.

If a fleck coat or cobwebbing of POLYCOR® 968 HG Series enamel is desired over the base coat of enamel, it should be applied while the base coat is wet.

Refer to Polynt's Composites Applications Guide ("Cookbook") for mixing, equipment, application and repair recommendations. Each user must determine the suitability of this product to his/her particular mode of operation and intended end-use application. A Polynt representative will be available to assist in the proper selection of all Polynt-Reichhold products available for commercial use.

SHELF LIFE & STORAGE

The shelf life of standard cure POLYCOR® 968 HG Series products is 120 days from the date of manufacture from Polynt. Fast cure products (gel time less than 9.0 minutes) have a 60 day shelf life. To maximize usage life and maintain optimum properties, resins and gel coats should be stored in the original closed container at temperatures below 23°C/73°F and away from ignition sources and sunlight. Keep containers sealed to prevent moisture pick-up and monomer loss.

RELATED PRODUCTS

Polynt recommends using THERMACLEAN® REPLACETONE™ 095-0030 to clean surfaces coated with POLYCOR® 968 HG Series enamels. Use of other cleaners may dull the surface.

PATCHAID® 970XJ037, 970X900, 970XJ166 and 970XA014 – Resin based products that can be mixed into the gel coat to improve the working properties of spray patches.

SAFETY & WARRANTY

To receive a copy of our safety and warranty information, please email safetyandwarranty@polynt.com.